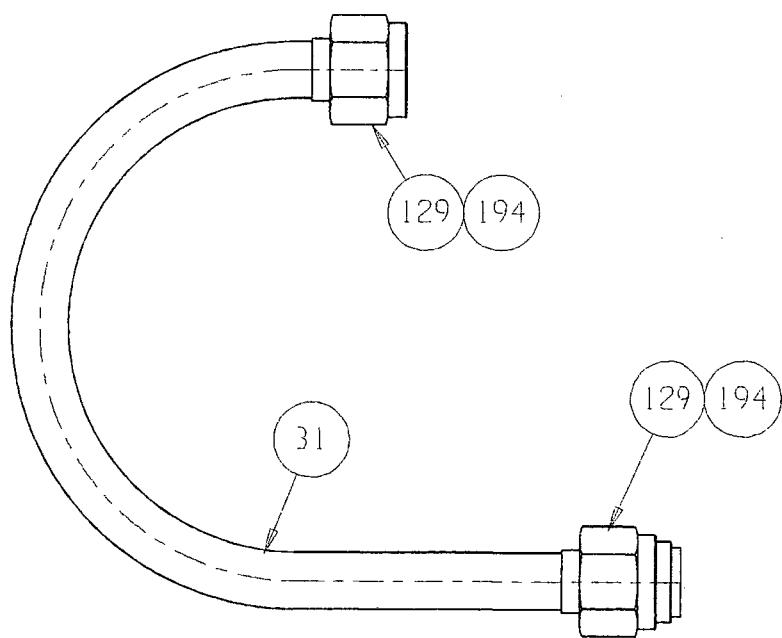


DART AEROSPACE LTD	Work Order:	24027
Description: <u>Tube Ass</u>	Part Number:	K469-035-002A
Dwg:	Qty:	2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler		11.05.08.22	2
2	GA	CUT FORM TUBE AS PER Dwg : DT 8786 Template. MAT : 316SS Seamless Tubing Ø.750" x .025" WALL (M316T0750W025) Batch:.			
3	GA	Deburr.			
4	GA	Pick:			
		Qty <u>Part#</u> <u>Loc</u> <u>Batch</u>			
		2 ms21922-12. STORE			
		2 ms21921512 NJT			
		<i>Assemble as per Dwg : DT 8786</i>			
5	QC	Inspect Work to Step #4.			
6	ST	Identify & Stock in Kwick Float Room			
7	AC	Cost/PART.		5/10/08.23	
8	DC	<i>Close w/o Level 21.</i>			

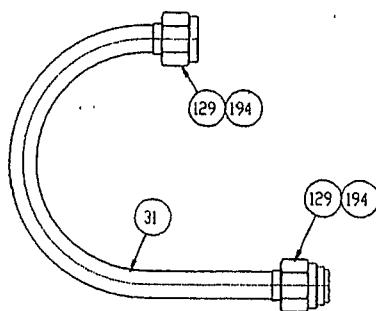
Rev	Date	Change	Revised By	Approved



DETAIL OF PART No. 469-035-002A

REFER TO HELITECH PROCESS SPECIFICATION
PS031 FOR MANUFACTURE AND TEST DETAILS

A

BOTTLE RACK CL
FOR CLARITY

43

B

56 139 182 186

TYP. 2 PLACES
183 187

146 185

144

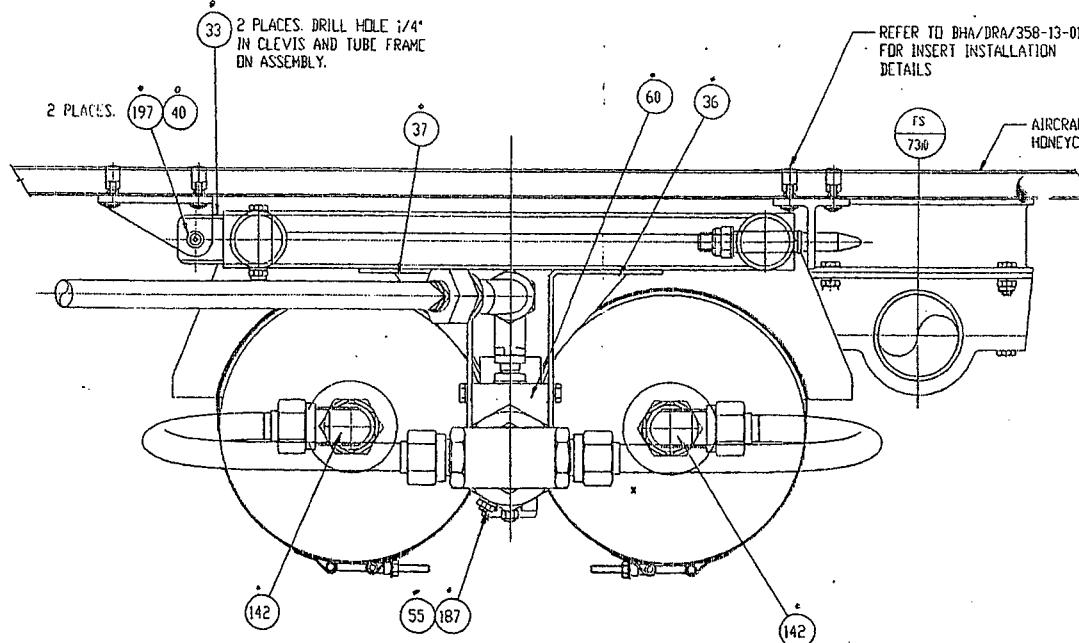
304

C

DETAIL OF PART No. 469-035-002A 43
 REFER TO HELITECH PROCESS SPECIFICATION
 PS031 FOR MANUFACTURE AND TEST DETAILS

D

E

BOTTLE RACK CL
FOR CLARITY TYP

F

DETAIL OF ASSEMBLY 469-021-001 (1)
 NOTE: '*' INDICATES PART NOT SHOWN.
 HELICOPTER STRUCTURE & MOUNTS OMITTED

G

H

REFERENCE DRAWINGS

MANUFACTURING OPERATIONS

MATERIAL

DIMENSIONS IN INCHES (mm)

BHA/DRA/358-01-01	MATERIALS LIST
BHA/DRA/358-01-02	MATERIALS LIST (CONTINUED)

ALL DIMENSIONS TO BE NET AFTER PLATING. REMOVE ALL BURRS. BREAK ALL SHARP EDGES 0.015"-0.031" 0.4mm-0.8mm	SURFACE ROUGHNESS UNLESS INCLUDING REAMED HOLES FOR DRILLED HOLES
	BEAD RADIUS
	CORNERS AND FILLETS
OVER-UP TO TOLERANCE	MARK PART A IN REGION MARKED

OVER-UP TO TOLERANCE	WELDING ALL WELDING FULL PENETRATION A 3mm BEAD MUST REMAIN ON AT LEAST ONE SIDE UNLESS
ANGULAR TOLERANCE (UNLESS) +/- 05°	

	TREATMENT

0000000000

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 09, 2005
02:01 pm

Work Order No : 0024027
Project Name : k469-035-002A Department Code:
Project For : WK534 Burden Flags : NNNNNNN
Work Order Type : Main WO Status : Open
Main WO Number : Invoice State : Not Invoiced
House Part Number : k469-035-002A Invoice Date :
Description : Tube Assembly Invoice Number :
Manufactured : No Invoice Amount : 0.00
Amount Req'd : 0
Amount Done : 0 Order Entry No :
Start Date : 08-09-05 OE Value : 0.00
Est Finish Date : 08-24-05
Act Finish Date :
Drawings Reqd : No Est Margin : 0.000%
Ok for Approval : Actual Margin : 0.000%
Approval Rec'd : \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

2x MS21922-2 sleeve

Page 3

Make by hand
Searled
3/4 3/16 ss

2x MS219215/2 nut plates
bolts

0625W411